

Work Order ID 117854

117854

May-23-14 11:39:37 AM

Item ID: D3065-5 Accept *N900040100* Setup Start *NS1*

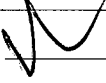
Revision ID: Stop *NS2*

Item Name: Step Leg

Start Date: 5/05/14 Start Qty: 80.00 *80* Cust Item ID:

Required Date: 5/05/14 Req'd Qty: 80.00 *80* Customer:

Reference:

Approvals: Process Plan:  Date: _____ Tooling: _____ Date: _____ Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3065	Rev B								

105

0.00

105

Purchasing

Purchasing

Memo

ISSUE PO 24388

1-Cut as per Dwg

Dwg Rev: _____

Prog Rev: _____

2-Deburr if necessary

N/A

MLJ 14-07-14

CX 14/05/28 80

115

Receive & Inspect for Damage & Mat'l Certs

0.00

115

Packaging

Packaging

Memo

0.00

14/4/18 (80)

Work Order ID 117854

May-23-14 11:39:37 AM

117854

Page 2

Item ID: D3065-5

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Step Leg

Start Date: 5/05/14

Start Qty: 80.00

80

Cust Item ID:

Required Date: 5/05/14

Req'd Qty: 80.00

80

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start ***NR1***

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

125

QC6- Inspect dimensions to drawing

0.00

125

QC

Memo

0.00

Quality Control

DAS
27
9-89
14/6/20

80

130

Chemical Conversion Coat per QSI005 4.1

0.00

130

HandFinish

Memo

0.00

Hand Finishing

80 7/14/23

140

QC7-Inspect Chemical Conversion Coat

0.00

140

QC

Memo

0.00

Quality Control

80K

DAS
36
9-89
14/07/14

May-23-14 11:39:37 AM

Page 3

Accept

Setup Start

NS1

Stop

NS2

Start Date: 5/05/14 **Start Qty:** 80.00

80

Cust Item ID:

Required Date: 5/05/14 **Req'd Qty:** 80.00

80

Customer:

Reference:

Run Start

NR1

Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop

NR2

QC:

Date:

SPC (Y/N):

Date:

**Insp.
Stamp**

Identify as per dwg & Stock Location:

6.A

0.00

150

Packaging

Memo

0.00

Packaging

160

QC21- Final Inspection - Work Order Release

0.00

160

QC

Memo

0.00

Quality Control

80x

14/07/14

DAS
36
9-89

MLJ 14-07-14

14-72

Picklist Print

May-23-14 11:39:36 AM

Page 1

Work Order ID: 117854

117854

Parent Item: D3065-5

D3065-5

Parent Item Name: Step Leg

Start Date: 5/05/14

Required Date: 5/05/14

Start Qty: 80.00

Required Qty: 80.00

Comments:

IPP: C02.11.01Incorporated D3066-1 IPPKJ/RF

IPP Rev:D Now on Water Jet 06-04-11 JLM

IPP Rev:E Now manufactured with 6061-T6 06-05-25 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M6061T6S.080

Purchased

No

100

sf

382.5600

0.825

70

M6061T6S 080

CLY/06/10

6061-T6 .080 Sheet

m 129439

Location

Loc Qty

Loc Code

MAT021

382.56

m126309

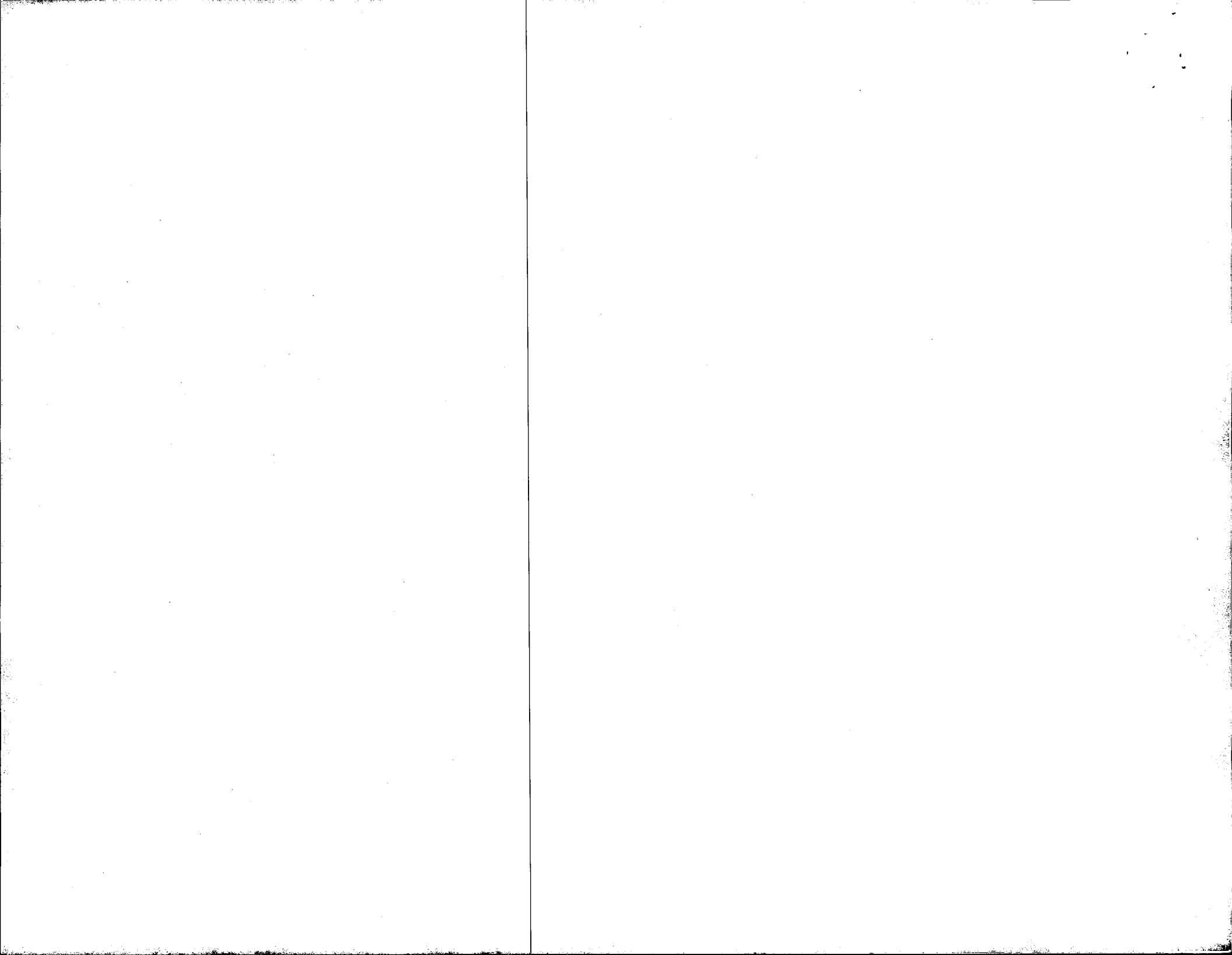
130.52

m126350

13.34

m128903

238.7



DART AEROSPACE LTD		Work Order:	117854
Description: Step Leg		Part Number:	D3065-5
Inspection Dwg: D3065 Rev: B		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
16.458	+/-0.010	16.458	✓		ED 11	
15.750	+/-0.005	15.750	✓		ED 11	
2.250	+/-0.005	2.250	✓		QCI 07	
3.460	+/-0.005	3.460	✓		QCI 07	
0.865	+/-0.005	0.865	✓		QCI 07	
6.020	+/-0.005	6.020	✓		QCI 07	
1.205	+/-0.005	1.205	✓		QCI 07	
3.484	+/-0.005	3.484	✓		QCI 07	
0.871	+/-0.005	0.871	✓		QCI 07	
8.325	+/-0.010	8.325	✓		QCI 07	
0.551	+/-0.010	0.551	✓		QCI 07	
0.213	+0.005/-0.000	0.213	✓		QCI 07	
Ø0.128	+0.005/-0.000	0.128	✓		QCI 07	

Measured by:	EB	Audited by:	DAS 27	Prototype Approval:	N/A
Date:	14/6/20	Date:	14/6/20	Date:	N/A

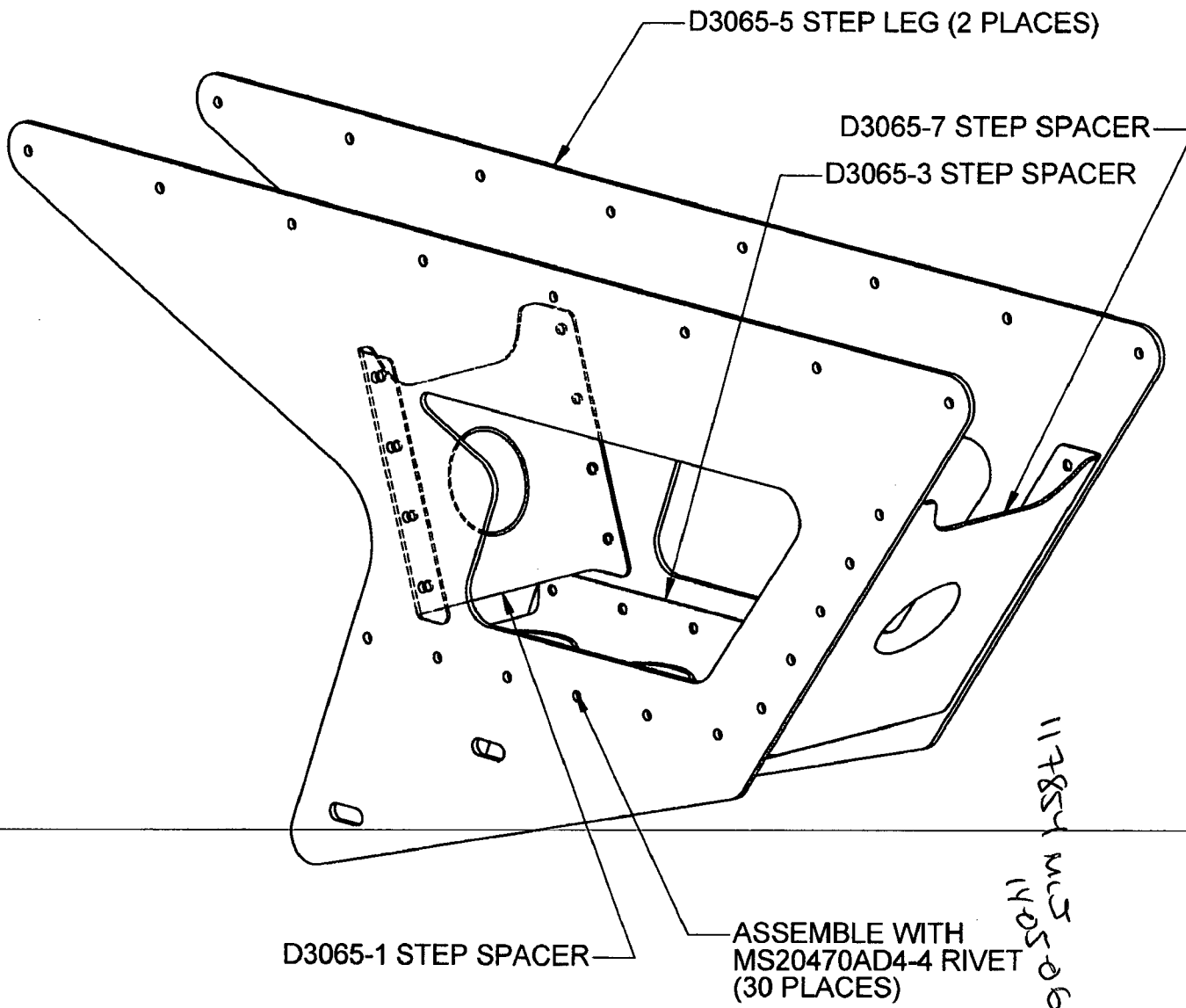
Rev	Date	Change	Revised by	Approved
A	03.09.22	New Issue P/O D3065-041	KJ/RF	
B	04.06.15	Added Ø0.128 dimension	KJ/JLM	
C	06.06.23	Dwg Rev. changed	KJ/JLM	



DESIGN <i>UP</i>	DRAWN BY <i>CB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3065	REV. B SHEET 1 OF 5
DATE 06.05.23		TITLE STEP LEG ASSEMBLY	SCALE 1:2
A	02.09.11	NEW ISSUE	
B	06.05.23	ADD 6061-T6 MATERIAL, ADD SLOTS TO D3065-5	

RELEASED

06.06.20 *[Signature]*



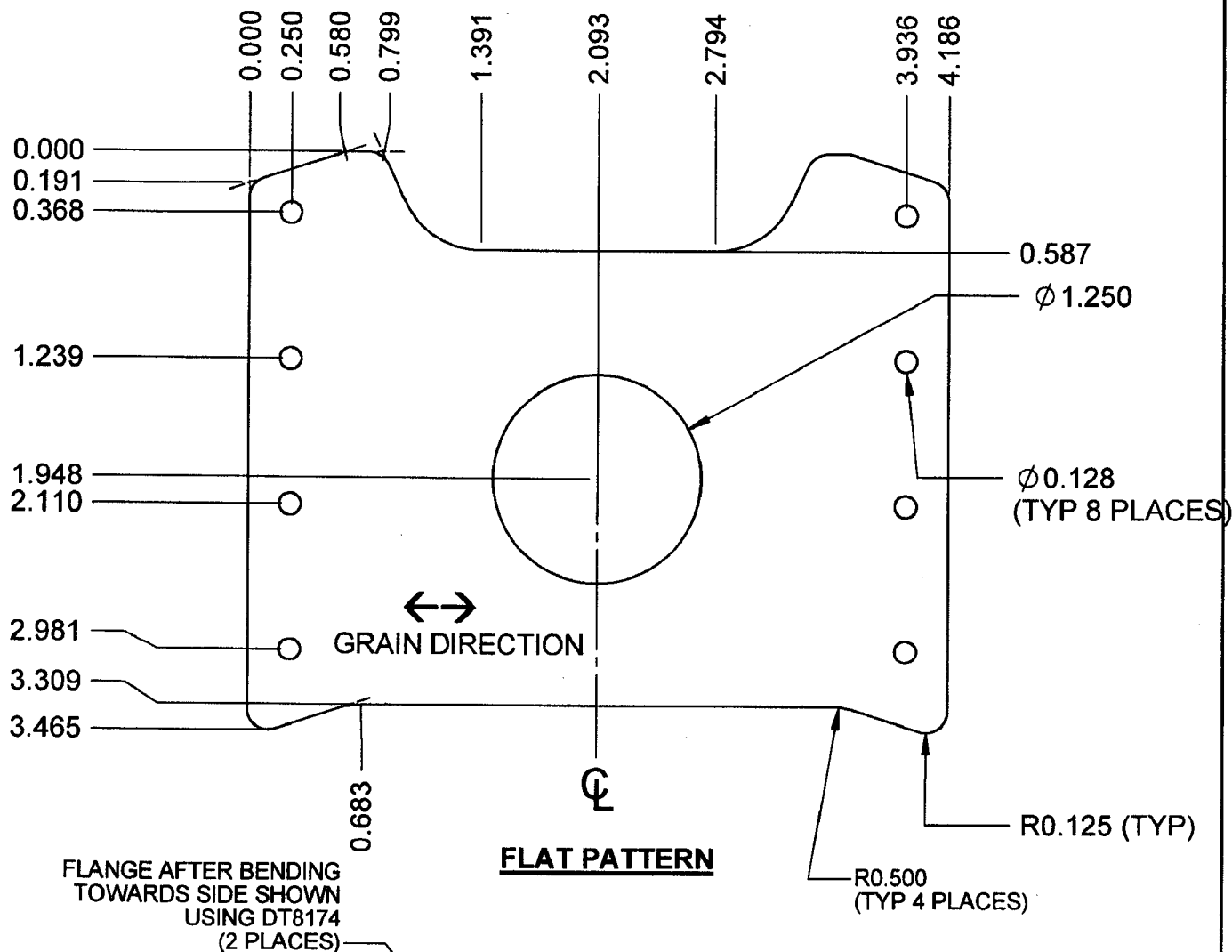
D3065-041 STEP LEG ASSEMBLY

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CHECKED PH	APPROVED [Signature]	DRAWING NO. D3065	REV. B SHEET 2 OF 5
DATE 06.05.23	TITLE STEP LEG ASSEMBLY		SCALE 1:1



RELEASED

4P 4P 20 [Signature]

D3065-1 STEP SPACER

BEND DETAIL

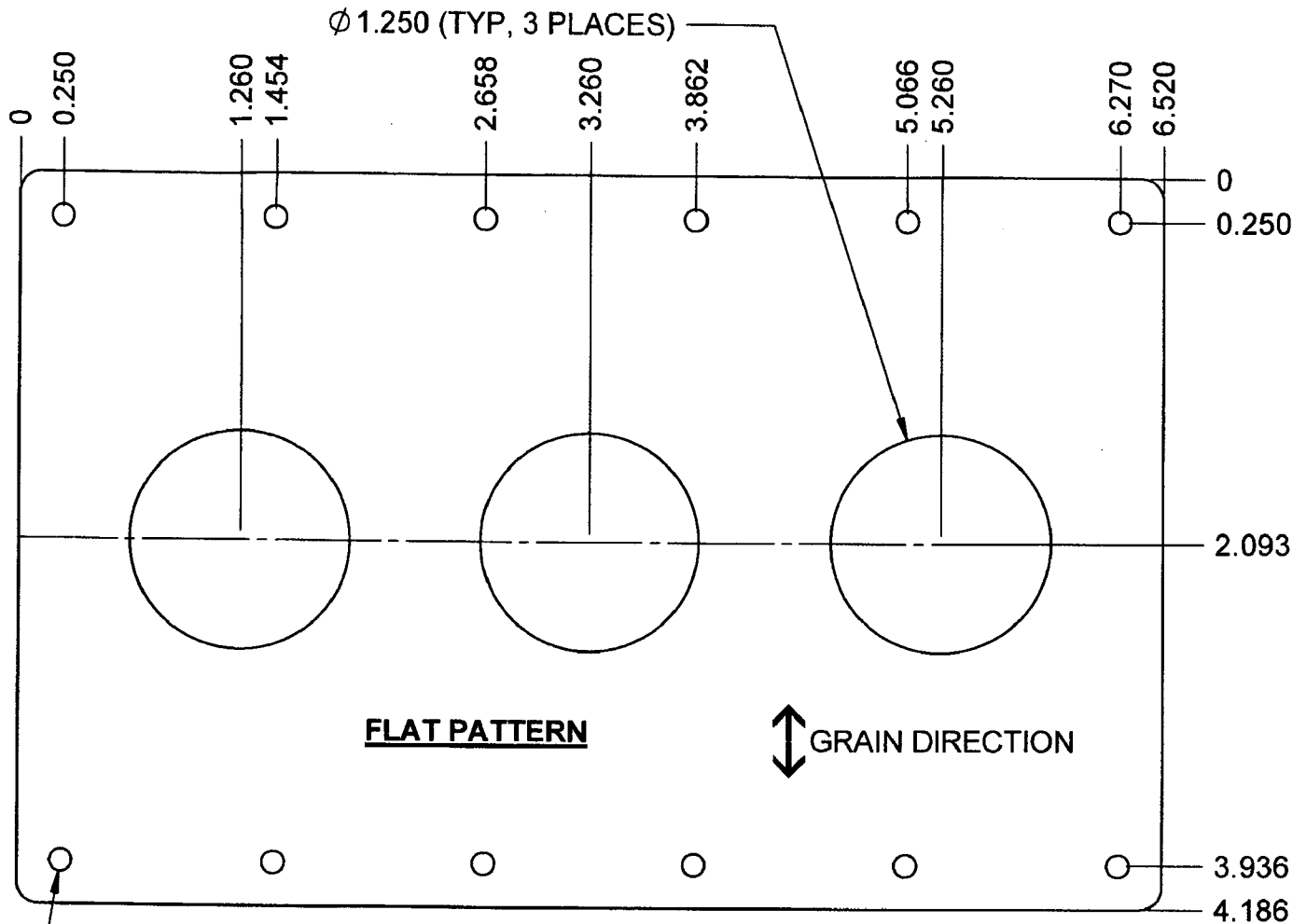
- 1) MATERIAL: 2024-T3 (QQ-A-250/4) 0.040 THICK (REF DART SPEC. M2024T3S.040)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) PART IS SYMMETRIC ABOUT CENTERLINE
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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CHECKED PH	APPROVED [Signature]	DRAWING NO. D3065	REV. B
DATE 06.05.23	TITLE STEP LEG ASSEMBLY		SHEET 3 OF 5 SCALE 1:1



FLANGE AFTER TOWARDS SIDE
SHOWN USING DT8174 (3 PLACES)

RELEASED

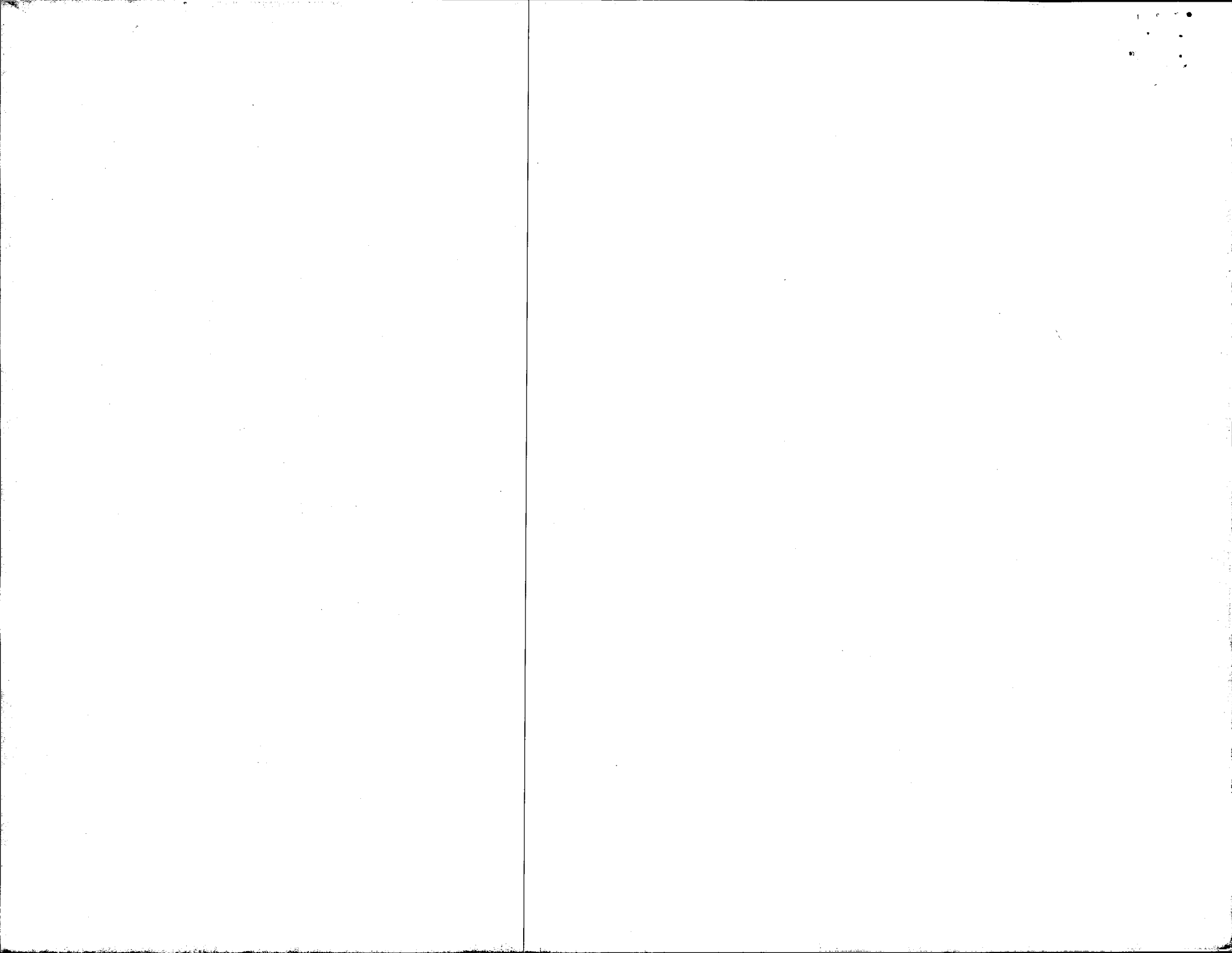
06.05.23 [Signature]

D3065-3 STEP SPACER

- 1) MATERIAL: 2024-T3 (QQ-A-250/4)
0.040 THICK (REF DART SPEC. M2024T3S.040)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 3) PART IS SYMMETRIC ABOUT CENTERLINE
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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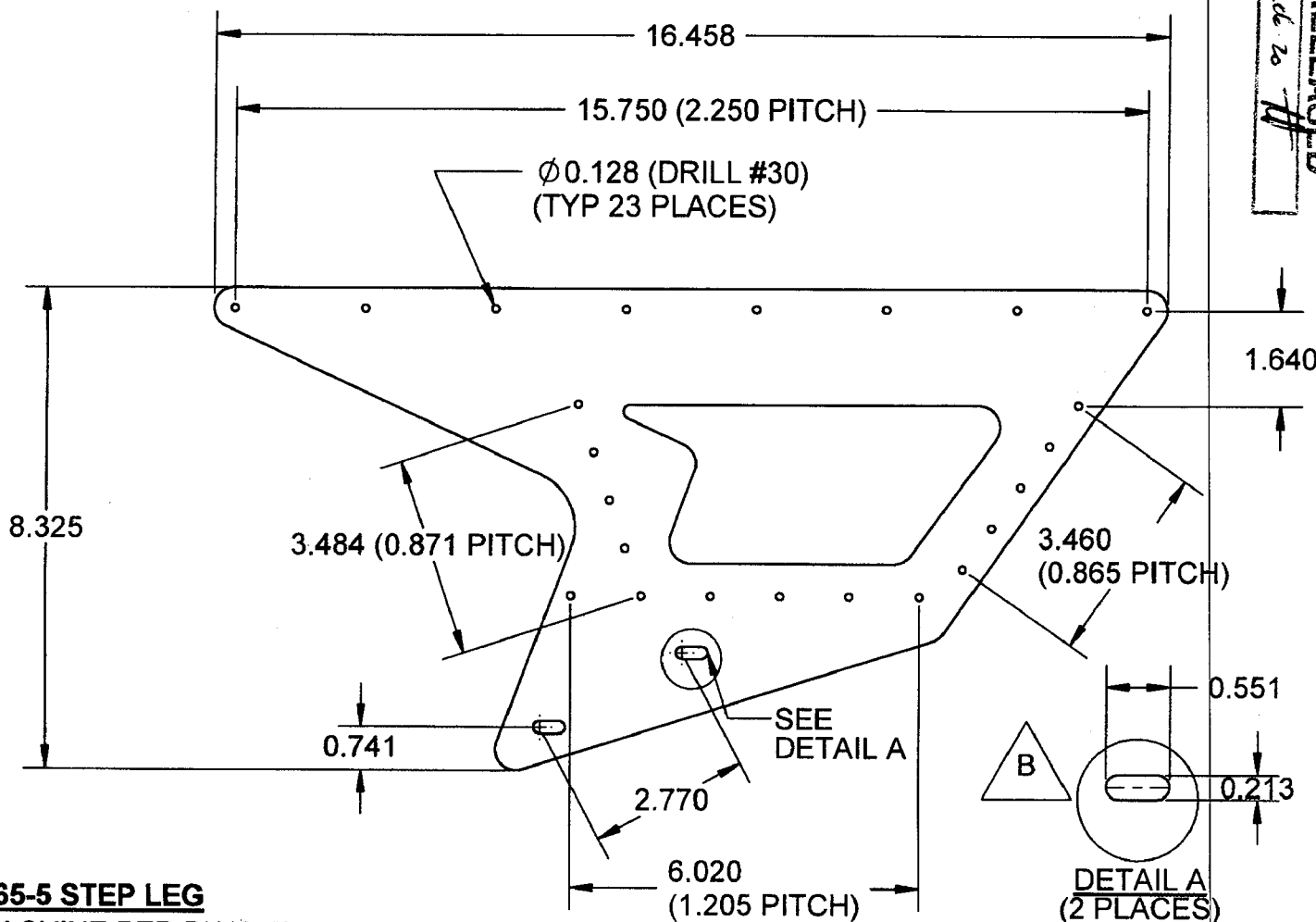


DART

DESIGN	40	DRAWN BY	CB	DART AEROSPACE LTD
				HAWKESBURY, ONTARIO, CANADA
CHECKED	PH	APPROVED	PH	DRAWING NO.
				D3065
DATE	06.05.23	TITLE	STEP LEG ASSEMBLY	REV. B
				SHEET 4 OF 5
				SCALE
				1:3

RELEASED

06.06.20



D3065-5 STEP LEG

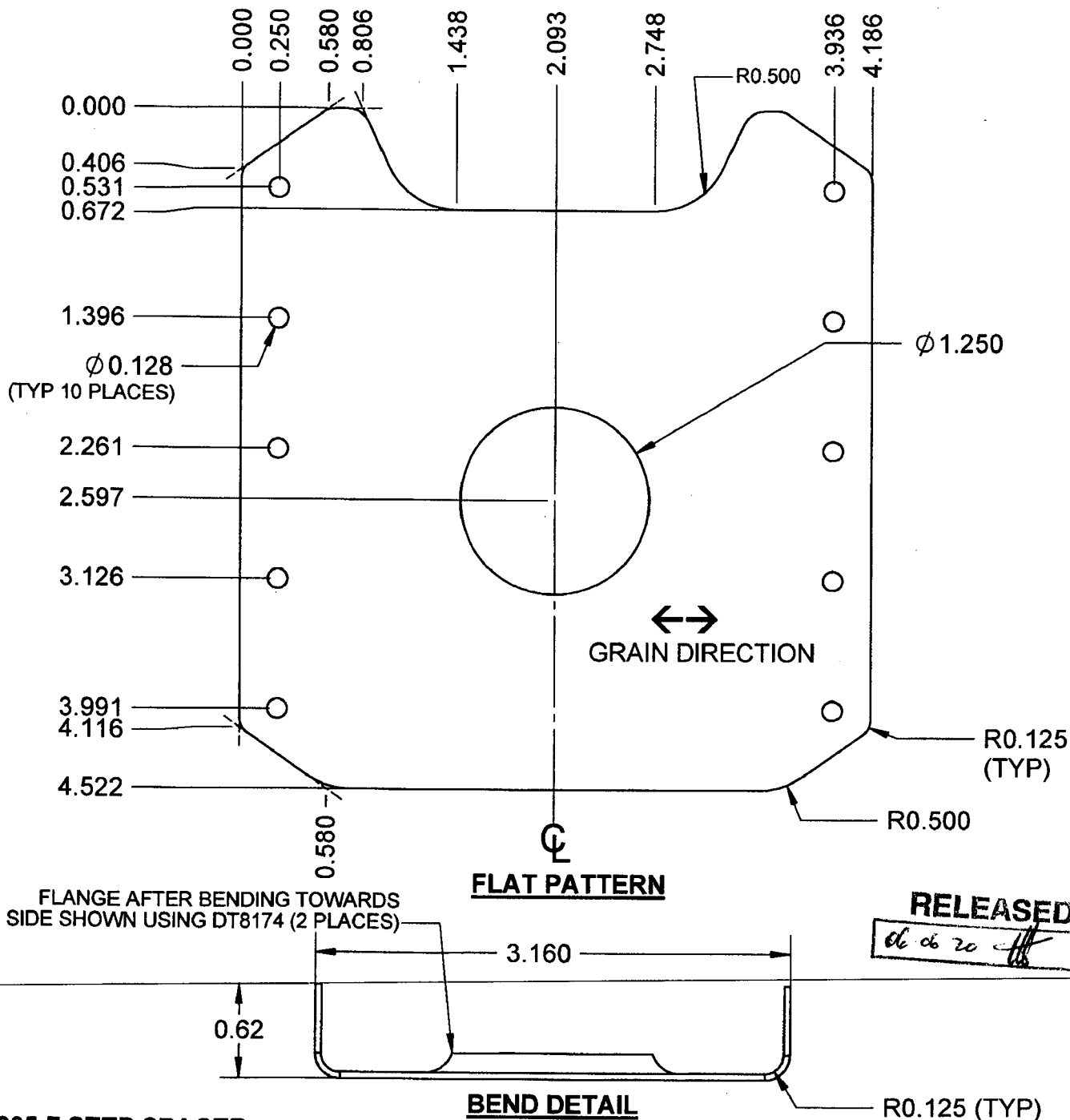
- 1) MACHINE PER DWG FILE "D3065-5.SLDPRT"
- 2) MATERIAL: 6061-T6 (PER QQ-A-250/11 OR AMS 4025 OR AMS 4027) 0.080" THICK (REF DART SPEC M6061T6S.080)
OR
5052-H32 (PER QQ-A-250/8 OR AMS 4016) 0.080 THICK (REF DART SPEC. M5052H32S.080)
- 3) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3065	REV. B SHEET 5 OF 5
DATE 06.05.23	TITLE STEP LEG ASSEMBLY		SCALE 1:1



D3065-7 STEP SPACER

- 1) MATERIAL: 2024-T3 (PER QQ-A-250/4) 0.040 THICK (REF DART SPEC. M2024T3S.040)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 3) PART IS SYMMETRIC ABOUT CENTERLINE
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO24388

Purchase Order Date 5/28/2014

PO Print Date 6/10/2014

Page Number 1 of 5

Order From :

VC-TPI001

TPI INDUSTRIES INC.
148 RUE GOODFELLOW
DELSON, QUEBEC J5B 1V4
CANADA

Ship To : DART AEROSPACE LTD
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

REUSED \$

Contact Name

Vendor Phone 450-633-0484

Buyer

Chantal Lavoie

Customer POID

Customer Tax # 10127-2607

Terms Net 30

Currency CAD

FOB Destination-Collect

Ship To Contact

Ship To Phone

Ship Via:

Ship Acct:

Line Nbr	Reference Vendor Part Number Line Comments Delivery Comments	Description/ Mfg ID	Req Date/ Taxable Promise Date	CD	Req Qty/ Unit of Measure	PO Unit Price	Extended Price
1	117871 CUT AS PER DWG D2278	D2278 STEP LEG	6/20/2014 Yes 6/20/2014		50.00	\$8.42	\$421.00
						Line Total:	\$421.00
2	117854 CUT AS PER DWG D3065-5	D3065-5 STEP LEG	6/20/2014 Yes 6/20/2014		80.00	\$9.13	\$730.40
						Line Total:	\$730.40
3	119043 CUT AS PER DWG D3594	D3594-4 FLOOR DOUBLER	6/20/2014 Yes 6/20/2014		20.00	\$3.00	\$60.00

Note:

6/10/2014

T.P.I. INDUSTRIES INC.

148 GOODFELLOW
DELSON, QUÉBEC J5B 1V4
CANADA
Tel: (450) 633-0484
Fax: (450) 633-0879

Packing Slip

Packing Slip No.: 6152
Date: 2014-06-17
Page: 1

Sold to:	Ship to:
Dart Aerospace Michael Grégoire 1270 Aberdeen Hawkesbury, Ontario K6A 1K7 Canada	Dart Aerospace Michael Grégoire 1270 Aberdeen Hawkesbury, Ontario K6A 1K7 Canada
Order No.: 24388	Sold By: JONATHAN LESSARD
Shipped By:	Ship Date: 2014-06-18
Tracking No.:	

Item No	Unit	Description	Quantity
d2278	Chaque	d2278 step leg	50
d3065-5	Chaque	d3065-5 step leg	80
d3594-4	Chaque	d3594-4 floor doubler	20
d3594-3	Chaque	d3594-3 floor doubler	20
d3208-7	Chaque	d3208-7 filler	20
d2935	Chaque	d2935 saddle spacer	40
d3066-1	Chaque	d3066-1 spacer	80
d3065-5	Chaque	d3065-5 step leg	40
d3578-1	Chaque	d3578-1 doubler	24
d3594-5	Chaque	d3594-5 doubler	
Comment: Net / 30 from date of invoice 2% svc. chg. on invoices over 30 days			